



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3370-3
Job Sheet 201333-A



Part No: D3370-3

Job Qty: 1 pcs

Part Name: Pedal Lock Cover



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/3/19

Job Tracking No:

Due Date: 10/4/19

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV C IPP B 05.05.25 Added Powder Coat KJ/JLM IPP Rev:C 08-07-17 revC as per dwg DD verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
160	QC 3	1 pcs	10/4/19	10/4/19	0.00	0.00	QC 3 - 10		
							QC 3 - 13		
							QC 3 - 15		
							QC 3 - 17		
							QC 3 - 18		
							QC 3 - 2		
							QC 3 - 28		
							QC 3 - 3		
							QC 3 - 30		
							QC 3 - 34		
							QC 3 - 36		
							QC 3 - 41		
							QC 3 - 51		
							QC 3 - 58		
							QC 3 - 59		
							QC 3 - 68		
							QC 3 - 9		
							QC 3 - 40		
							QC 3 - 19		
							QC 3 - 43		
							QC 3 - 24		
							QC 3 - 61		
							QC 3 - 81		
170	Packaging 3-1 - Stock - B4B	1 pcs	10/4/19	10/4/19	0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		
							Packaging 3 - 8 - B4B		
							Packaging 3 - 9 - B4B		

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				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21
				QC 21 - SA - 53	9-30
180	QC 21 - SA	1 pcs	10/4/19	0.00 0.00	OCT 03 2019
Part Op 160 - (QC3- Inspect Part Finish) Descriptions: 170 - (Identify as per dwg & Stock Location: _____) 180 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Job BOM records could not be found.					
Job Allocations					
Job Allocations could not be found.					

Part Specifications

Specifications could not be found.



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POSITIVE RECALL

EFFECTIVE 10/10/19

AUTH SLD

D3370-3

RELEASED

DATE Job Sheet 201333



Split 3

Part No: D3370-3

Job Qty: 4 pcs

Part Name: Pedal Lock Cover



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/1/19

Job Tracking No:

Created By: Linda Lacelle

Due Date: 10/3/19

Type: SOLD

Description:

Note: DWG REV C IPP B 05.05.25 Added Powder Coat KJ/JLM IPP Rev:C 08-07-17 revC as per dwg DD verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	4 pcs	10/3/19	10/3/19	0.00	0.14	Bandsaw - 1		19/10/1
110	HAAS 4 Axis - B4B	4 pcs	10/3/19	10/3/19	1.00	3.81	HAAS - 1 - B4B		DAS 23 9-89
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
120	QC 2	4 pcs	10/3/19	10/3/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		



Container No: S218851



Part: D3370-3

Job No: 201333

Serial No/Batch: S218851

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

DART Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 10/01/19

P.T.O
last page

DAS
23
9-89

130 QC 8	4 pcs	10/3/19	0.00 0.00	QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	B. 19-10-01
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
140 Handfinish - 1-1 Chemical-B4B	4 pcs	10/3/19	0.00 0.53	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 -	



150 Powdercoat - 6 Fin Red - B4B 4 10/3/19 0.00 0.23
M104558 pcs

START: 11:20 O.U.T. 320° FINISH 11:50

160 QC 3 4 10/3/19 0.00 0.00
pcs

B4B
Handfinish - 1 - 18 -
B4B
Handfinish - 1 - 19 -
B4B
Handfinish - 1 - 20 -
B4B
Handfinish - 1 - 21 -
B4B
Handfinish - 1 - 22 -
B4B

Powdercoat - 1 - B4B
Powdercoat - 2 - B4B
Powdercoat - 3 - B4B
Powdercoat - 4 - B4B

BA 19-10-2

QC 3 - 10
QC 3 - 13
QC 3 - 15
QC 3 - 17
QC 3 - 18
QC 3 - 2

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81
9-89

OCT 02 2019

Bring these 4 parts to
Steven Droun (Positive Recall)

BA 19-10-01

170 Packagi

Packaging 3 - 2 - B4B
Packaging 3 - 3 - B4B
Packaging 3 - 4 - B4B
Packaging 3 - 5 - B4B
Packaging 3 - 6 - B4B
Packaging 3 - 7 - B4B
Packaging 3 - 8 - B4B
Packaging 3 - 9 - B4B
Packaging 3 - 10 - B4B
Packaging 3 - 11 - B4B
Packaging 3 - 12 - B4B
Packaging 3 - 13 - B4B
Packaging 3 - 14 - B4B
Packaging 3 - 15 - B4B
Packaging 3 - 16 - B4B
Packaging 3 - 17 - B4B
Packaging 3 - 18 - B4B
Packaging 3 - 19 - B4B
Packaging 3 - 20 - B4B
Packaging 3 - 21 - B4B
Packaging 3 - 22 - B4B

				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
180 QC 21 - SA	4 pcs	10/3/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	
Part Op 100 - (Bandsaw) Cut blank: 1.500" x 2.500" x 4.120" long Descriptions: 110 - (HAAS CNC Vertical Machine) Machine D3370-3 as per Folio FA483 and Dwg D3370 Identify as D3370-3 120 - (QC2- Inspect parts off machine FAI/FAIB) 130 - (QC8- Inspect parts - second check) 140 - (Chemical Conversion Coat per QSI005 4.1) 150 - (Fire Red(Ref:4.3.5.10) per QSI005 4.3) Heat oven at temperature for 45 minutes before putting part in oven by: _____ 160 - (QC3- Inspect Part Finish) 170 - (Identify as per dwg & Stock Location: _____) 180 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M6061T6B1.500X2.500	6061-T6 Bar 1.50 X 2.50	1.3932 ft (.3483 ea)	100-Bandsaw - 1	S207687	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Bandsaw - 1	M6061T6B1.500X2.500	1	32	0	
Part Specifications					
Specifications could not be found.					

Plex 10/1/19 11:53 AM dart.lacelle.linda

201333

DART AEROSPACE LTD	Work Order: 200380
Description: Pedal Lock Cover	Part Number: D3370-3
Inspection Dwg: D3370 Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.00	+/-0.030	3.980	✓		Vernier	VHJ-01
3.344	+/-0.010	3.346	✓		"	"
0.592	+/-0.010	0.592	✓		"	"
0.202	+/-0.010	0.202	✓		"	"
Ø1.000	+0.005/-0.000	1.000	✓		"	"
0.25	+/-0.030	0.260	✓		"	"
2.000	+/-0.010	1.9965	✓		"	"
0.300	+/-0.010	0.301	✓		"	"
0.550	+/-0.010	0.5525	✓		"	"
1.50	+/-0.030	1.4995	✓		"	"
Ø1.250	+0.005/-0.000	1.250	✓		"	"
0.635	+0.010/-0.000	0.6365	✓		"	"
Ø0.750	+0.010/-0.000	0.760	✓		"	"
1.673	+/-0.010	1.670	✓		"	"
0.430	+/-0.010	0.4265	✓		"	"
2.638	+/-0.010	2.637	✓		"	"
2.35	+/-0.030	2.348	✓		"	"
0.715 deep	+/-0.010	0.715	✓		"	"
15°	+/-0.1°	15°	✓		"	"
0.19 x 45°	+/-0.030	0.190	✓		"	"
0.450	+/-0.010	0.440	✓		"	"
1.450	+/-0.005	1.451	✓		"	"

Measured by: VHS	Audited by: A. A.	Preliminary Approval:
Date: 19/9/26	Date: 19-10-01	Date:

Rev	Date	Change	Revised by	Approved
A	05.01.05	New Issue	KJ/JLM	
B	05.04.26	Revised dimensions	KJ/JLM	
C	06.05.25	Revised dimensions	KJ/JLM	
D	10.04.20	Dimensions revised per Dwg Rev C	KJ	

Entered:

Date:

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No.

Route update only



Job: 201333		DISPOSITION		DEPARTMENT/PROCESS				Engineering							
Part No. D3310-3		Rework ☐ Scrap ☐ Use-as-is ☐		Skid-tube ☐ Machining ☒ Large Fab ☐		Cross tube ☐ Small Fab ☐ Finishing ☐		Eng. (Non-AW) Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐		Water Jet ☐ Supplier ☐ Quality ☐					
Date: 19-10-01		Sequence #: 110		QTY Affected: 4		MRS (QS1042)		51 19/10/03		9-89					
Description Work Order Deviation				Disposition											
The 2 (8-32 UNC) holes were taped for a (8-32 UNC HELICOIL) on 4 parts				Acceptable to use Helicoil with at assembly Helicoil 8-32 batch # MS21209C0815 Lot # 111111 BTH											
Completed By <i>[Signature]</i> 19/10/11				Lead hand / Supervisor				B. 19-10-01							
QC / QA Coordinator															
Root Cause				FAULT CATEGORY											
Operator ☒ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐				Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☒ Fit/Function ☐				Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐				Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐			
Other/Details:															